

Date Thursday, 16/08/2007 11:31:48 AM  
 User Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HELI ACCESS HANDLE WELDMENT ASS'Y, LH		
Job Number	: 34014					
Estimate Number	: 10946					
P.C. Number	: N/A					
This Issue	: 16/08/2007		S.O. No.	: N/A		
Prsht Rev.	: NO					
First Issue	: N/A		Type	: LARGE FAB ASSY		
Previous Run	: N/A					
Written By	: <u>  </u>					
Checked & Approved By	: <u>  </u>					
Comment	: Est. B1 03.01.09 added Powder Coat					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2478	Lower Arm	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)	
		Lower Arm	
		Pick:	
	Qty	Part number	Description
	1	D2478	Heli Access Handle <u>B34030</u>
2.0	D2479	Upper Arm	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)	
		Upper Arm	
		Pick:	
	Qty	Part number	Description
	1	D2479	Heli Access Handle <u>B34031</u>
3.0	D2481	Lower Mount Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)	
		Lower Mount Plate	
		Pick:	
	Qty	Part number	Description
	2	D2481	Mounting Plate <u>B23503</u>
4.0	D2482	Upper Mount Plate	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)	
		Upper Mount Plate	
		Pick:	
	Qty	Part number	Description
	1	D2482	Mounting Plate <u>  </u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes      No      DQA:      Date: 27/10/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 11:31:48 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS HANDLE WELDMENT ASS'Y, LH

Job Number: 34014

Part Number: D2480011

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Template DT 8333 (DT 2480 CJ)

89  
07/10/17

55

6.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

01-10-19 (5)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5x01018 x SRH

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M10S068

5xRH

m-f 07/10/20

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11/10/21

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PC11061

5

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

11/10/20

Job Completion



11/10/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

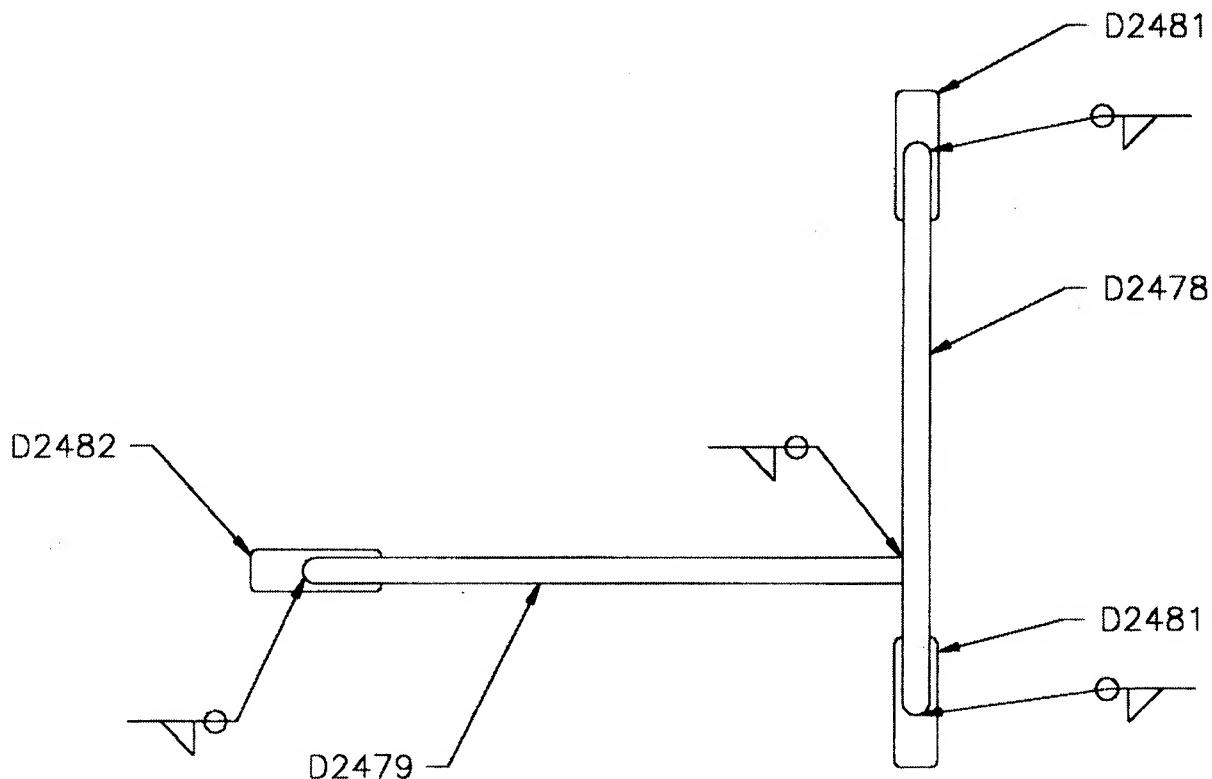
NOTE: Date & initial all entries

34036  
34031



DESIGN B. WILLIAMS	DRAWN BY MIKE M	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA		
CHECKED B.W.	APPROVED B.W.	DRAWING NO. D2480	REV. A	SHEET 1 OF 1
DATE 96:05:14		TITLE HANDLE WELDMENT ASSEMBLY	SCALE 6:1	
A1	05.06.23	ADDED POWDER COAT		

RELEASED  
96/05/02 DS



D2480-011 LH SHOWN  
D2480-012 RH OPPOSITE

NOTES:

1) WELD PER TEMPLATE DT 2480 WG PER QSI 004  
2) POWDER COAT WHITE GLOSS (REF: 4.3.5.2) AS PER QSI 005